

Work Order ID 130117

130117

Page 1

February-24-15 8:51:29 AM

Item ID: D4983-041

Accept

N9000401.00

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cargo Hook Assembly

Start Date: 2/24/15 Start Qty: 7.00

7

Cust Item ID:

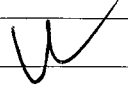
Required Date: 2/24/15 Req'd Qty: 7.00

7

Customer:

Reference: rework - ECN15-523

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

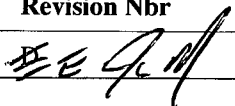
Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4983



0.00

100

100

Purchasing

Purchasing

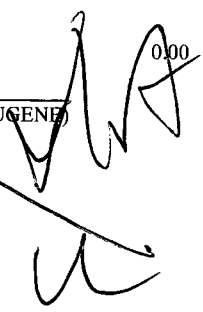
Memo

ISSUE PO:

TO: RED BARN (DART EUGENE)

C OF C IS REQUIRED

0.00



Work Order ID 130117

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130117

Page 2

Item ID: D4983-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cargo Hook Assembly
Start Date: 2/24/15 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 2/24/15 Req'd Qty: 7.00 ***7*** Customer:
Reference: rework - ECN15-523

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

105

0.00

105

Small Fab

Small Fab

Memo

0.00

PULL FROM STOCK:

7 X D4983-041

B127025

B127026

B127027

B127028

B127029

B127030

B127031

REWORK PER ECN15-523

REMOVE THE D5010-5 - PUT ASIDE, TO RETURN TO REDBARN FOR

REWORK

REPLACE WITH D5010-5 B130080

7 FF FEB 24 2015

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Quality Control

Memo

0.00

(7)

DAS

38

9-89

FEB 24 2015

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February-24-15 8:51:29 AM

Item ID: D4983-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Hook Assembly
 Start Date: 2/24/15 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 2/24/15 Req'd Qty: 7.00 ***7*** Customer:
 Reference: rework - ECN15-523

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>PPP128780 X2</u>	0.00							
130									
Packaging	Memo	5X 5T 461							
Packaging	RETURN TO STK USING NEW B/N	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

FEB 25 2015
 DAS
 06
 9-89

PTO
 →

15/2/25
 U-30225

DQA:

Date:

15/03/18



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/03/18

Work Order update only ☐

Work Order: <u>130117</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4983-041</u>	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. <u>15-4634</u>	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☒	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	Planning ☒	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY			
Landing Gear		General	
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☒ Other
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	

Picklist Print

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Work Order ID: 130117

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Parent Item: D4983-041

D4983-041

Parent Item Name: Cargo Hook Assembly

Start Date: 2/24/15

Required Date: 2/24/15

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A NEW ISSUE 14-03-022 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4983-041 *D4983-041* Cargo Hook Assembly		Manufactured	No				Each	0.0000		7			
D5010-5 *D5010-5* Interface Block		Purchased	No	- Removed			Each	0.0000	**			FF Feb 24 2015	
D5010-5 *D5010-5* Interface Block		Purchased	No	- Added B 120080			Each	0.0000	**				
										7		FF FEB 24 2015	

List Lots

February-24-15 8:38:33 AM

Page 1 of 1

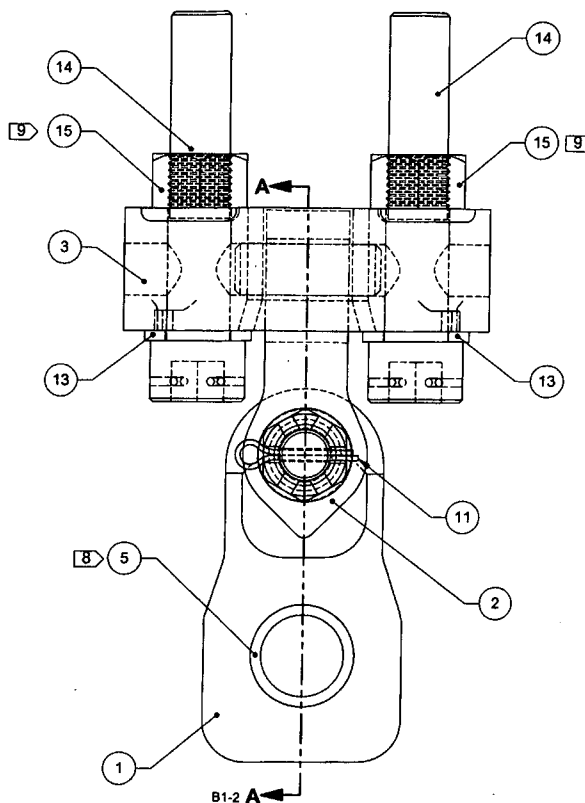
Criteria : Item ID: d4983-041 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D4983-041 Cargo Hook Assembly	Quarantine quarantine	127025	2/24/15	1.0000	QC21		
	Quarantine quarantine	127026	2/18/15	1.0000	QC21		
	Quarantine quarantine	127027	2/18/15	1.0000	QC21		
	Quarantine quarantine	127028	2/18/15	1.0000	QC21		
	Quarantine quarantine	127029	2/18/15	1.0000	QC21		
	Quarantine quarantine	127030	2/18/15	1.0000	QC21		
	Quarantine quarantine	127031	2/24/15	1.0000	QC21		
			Total:	7.0000			

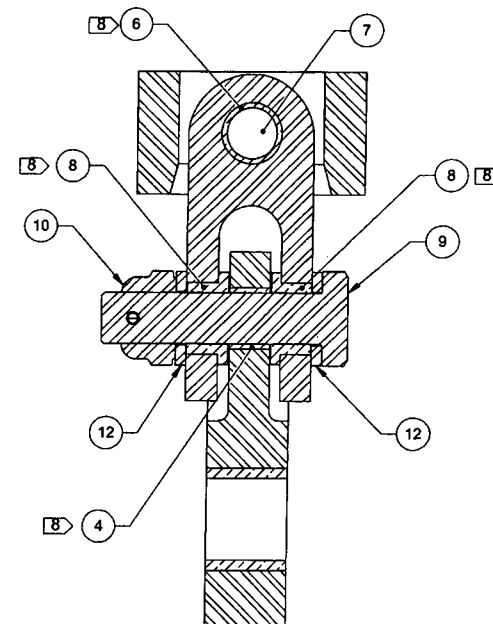
LOT TRACKING !!

Parent Item ID /	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
D4983-041	128780	-1	127024	2/04/15 7:40:48 AM	\$6,048.00
D4983-041	128780	-1	127031	2/04/15 7:40:48 AM	\$6,048.00
D4983-041	128780	-1	127025	2/04/15 7:40:48 AM	\$6,048.00
D4983-041	128780	-1	127032	2/04/15 7:40:48 AM	\$6,048.00
D5008-1	128780	-4	127033	1/28/15 7:30:56 AM	\$289.33
D5051-1	128780	-4	127035	2/04/15 7:40:48 AM	\$186.00
D5052-1	128780	-4	127018	1/28/15 7:30:56 AM	\$30.80
D5066-3	128780	-4	127037	1/28/15 7:30:56 AM	\$20.33
D5066-5	128780	-2	127039	1/28/15 7:30:56 AM	\$10.08
D5066-7	128780	-4	127041	1/28/15 7:30:56 AM	\$20.33
D5066-9	128780	-4	127043	1/28/15 7:30:55 AM	\$20.33
D5092-041	128780	-4	126652	1/28/15 7:30:55 AM	\$17.19
D5092-3	128780	-4	128534	2/04/15 7:40:49 AM	\$6.80
D5095-1	128780	-4	127036	1/28/15 7:30:55 AM	\$1.45
D5096-1	128780	-8	126653	1/28/15 7:30:55 AM	\$.54
D5108-1	128780	-3	116693	1/28/15 7:30:55 AM	\$26.27
D5116-041	128780	-4	128565	2/04/15 7:40:49 AM	\$284.88
M12883/55-01	128780	-4	m131068	1/28/15 7:30:55 AM	\$35.21
M6106/19-017	128780	-4	131015	1/28/15 7:30:55 AM	\$107.50
MS21042L06	128780	-4	m130325	1/28/15 7:30:54 AM	\$.23
MS21919WDG5	128780	-8	118354	2/04/15 10:24:32 AM	\$.74
MS24665-151	128780	-8	m128401	1/28/15 7:30:54 AM	\$.04
MS26574-20	128780	-4	m131156	1/28/15 7:30:54 AM	\$76.50
MS27039-08-10	128780	-8	m128799	1/28/15 7:30:54 AM	\$.09
MS35206-227	128780	-4	109369	1/28/15 7:30:54 AM	\$.16
MS35489-149	128780	-4	121692	1/28/15 7:30:53 AM	\$3.00
NAS43DD3-16N	128780	-7	m131420	2/04/15 7:40:48 AM	\$.41
NAS43DD3-16N	128780	-1	117065	2/04/15 7:40:48 AM	\$.41

ITEM	QTY	P/N	DESCRIPTION
	X	D5010-041	HOOK INTERFACE ASSY
1	1	D5010-1	CLEVIS BLOCK
2	1	D5010-3	PIVOT BLOCK
3	1	D5010-5	INTERFACE BLOCK
4	1	D5013-1	BUSHING
5	1	D5013-11	BUSHING
6	1	D5013-15	BUSHING
7	1	D5010-7	PIN
8	2	D5109-1	BUSHING
9	1	AN5C12	BOLT
10	1	AN310C5	NUT, CASTELLATED
11	1	MS24665-151	COTTER PIN
12	2	NAS1149C0563R	WASHER
13	2	NAS1149C0663R	WASHER
14	2	NAS1351-6H32P	SOCKET HEAD CAP SCREW
15	2	90473A215	HEX NUT, NON-LOCKING, ZINC PLATED CARBON STEEL, VENDOR: MCMaster CARR



D5010-041 HOOK INTERFACE ASSY



SECTION A-A B5-2
(ITEMS 13, 14 & 15 NOT SHOWN FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: PER QSI 044 6.7
- 7) WEIGHT: 1.03 lbs
- 8) ALL BUSHING TO BE LIGHT PRESS FIT
- 9) THREAD ITEM 15 TO THE BOTTOM OF THE THREAD ON 14 AS SHOWN. ITEM 15 MUST BE HANDTIGHT ONLY

RELEASED

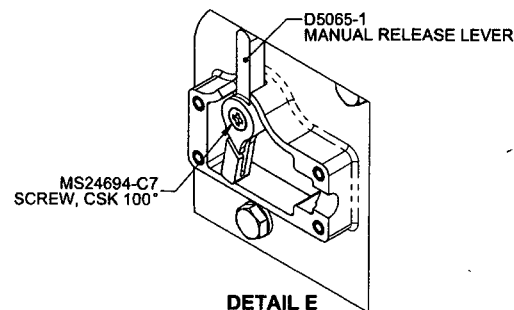
2015 FEB 23 *up*

APPROVED

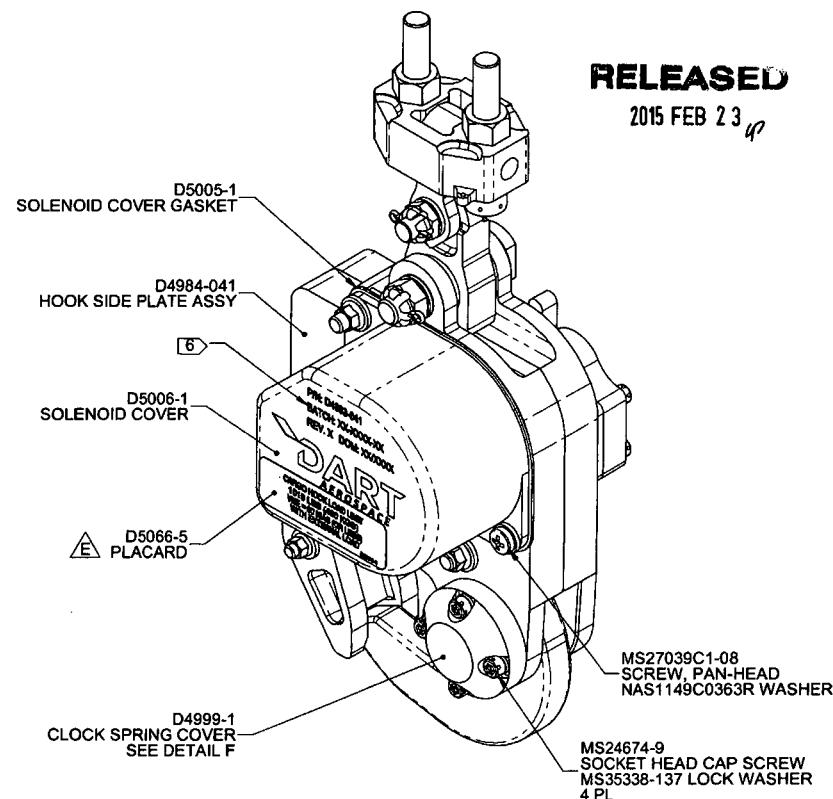
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. G
MFG. APPR.	JLM	D5010	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	HOOK INTERFACE ASSY	NTS
DATE	15.02.05	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED

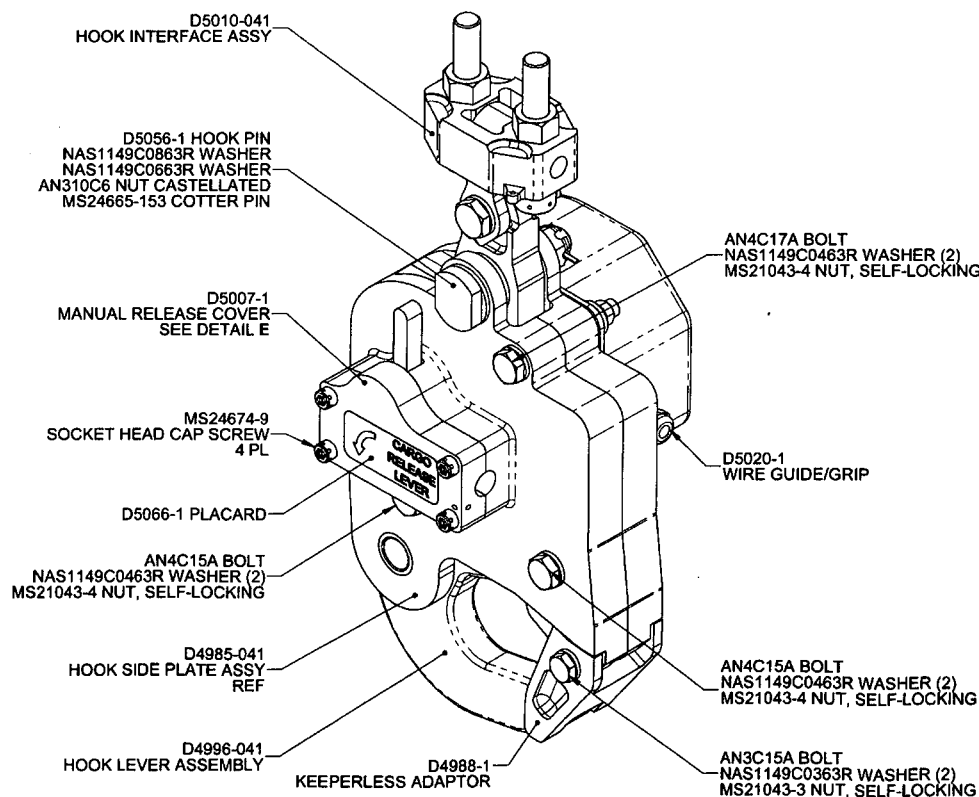
2015 FEB 23



DETAIL E



DETAIL F



BUILD SEQUENCE 3

APPROVED	DESIGN	AJS	DART AEROSPACE LTD	
	DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	CC	DRAWING NO.	REV. E
	MFG. APPR.	DD	D4983	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CARGO HOOK ASSY	NTS
DATE		15.02.06	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Linda Lacelle

From: Ryan Williamson
Sent: February-23-15 9:00 PM
To: Arkam Kindeel; Linda Lacelle; Sian Willems; Harvey Siemens
Cc: Marc Bellavance; Nigel Forbes
Subject: RE: R66 Cargo Hooks under review

Arkam,
You're exactly right. We will want back the D5010-5 to rework and will hold on to them until we run more Cargo Hook assemblies. We would also like to get the D5051-041 back so that we can destroy them.

Thanks,
Ryan

From: Arkam Kindeel
Sent: Monday, February 23, 2015 2:15 PM
To: Linda Lacelle; Sian Willems; Harvey Siemens; Ryan Williamson
Cc: Marc Bellavance; Nigel Forbes
Subject: RE: R66 Cargo Hooks under review

Hi Linda,

To answer your questions,

- 1) Does Ryan want the other parts back to rework? D5010-5 and D5051-041 ?

I believe that Ryan could re-work D5010-5 but most likely, not D5051-041.
Ryan, could you please confirm.

- 2) Do we just remove the D5051-041 off of the D4983-041's and replace with the new ones?

Yes, we can just remove D5051-041 from D4983-041 and replace with the new ones.

Regards,

Arkam

From: Linda Lacelle

Sent: February-23-15 1:28 PM

To: Sian Willems; Arkam Kindeel; Harvey Siemens

Cc: Marc Bellavance; Nigel Forbes

Subject: RE: R66 Cargo Hooks under review

Sian :QC have the parts... are all 20 of each part for customers that already have kits?

Harvey, Arkam:

- 1) Does Ryan want the other parts back to rework? D5010-5 and D5051-041 ?
- 2) Do we just remove the D5051-041 off of the D4983-041's and replace with the new ones?

LL